

Date:
User:Tuesday, 4/4/2006 1:32:36 PM
Kim Johnston

Process Sheet

Split SB 06/05/10

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26514 -2
 Estimate Number : 10911
 P.O. Number : N/A
 This Issue : 4/4/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : LARGE FAB ASSY
 Previous Run : N/A
 Drawing Name : LUG ASSEMBLY
 Part Number : D3405041
 Drawing Number : D3405 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 4/27/2006 Qty: 30 Um: Each
 Written By : See Comment Below
 Checked & Approved By : 06.04.04
 Comment : Est A 05.09.01 New Issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 952

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3405

Material release note is required

Identify as D3405-1

C 206/04/06 (30)

2.0

D34051F

GHW Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

G H W BRACKET

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

06/04/18

30

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3405

06-04-18 30

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3405

SAD 06/04/22 30

M.F. 06-05-13

SB 06/07/06

(30)

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries.

Date: Tuesday, 4/4/2006 1:32:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 26514

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-07-10

(20)

Comment: INSPECT WORK TO CURRENT STEP

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

B26536 -712

1 D3404-1

Lug

B24221 -78

A/R

SS Rod

M13066

PD 06-07-27 (20)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

PD 06-07-27 (20)

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/07/27 (20)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

06-08-01

(20)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/08/03 20

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST77

LB L.P. 06/08/03

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:32:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 26514

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



08

Comment: DOCUMENT CONTROL
Inspection Level 21

26/08/04

Job Completion



C206108104

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

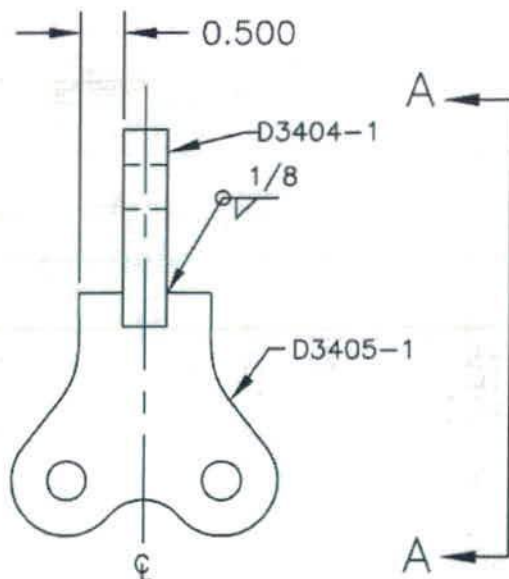
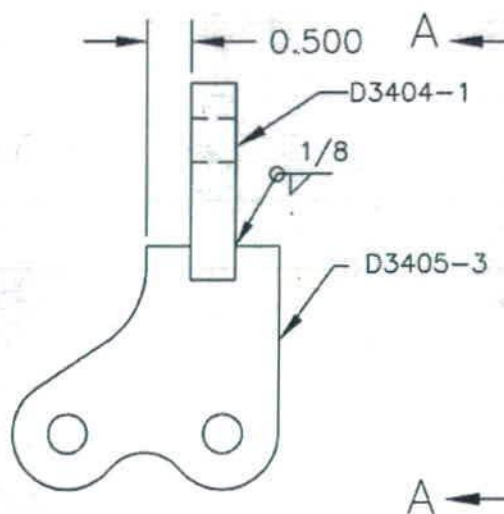
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

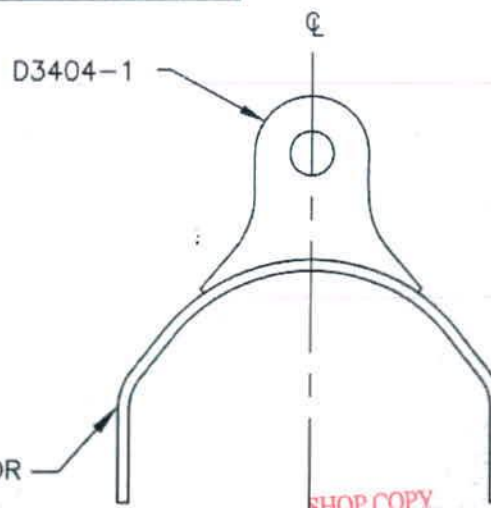
DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09 *[Signature]***D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES



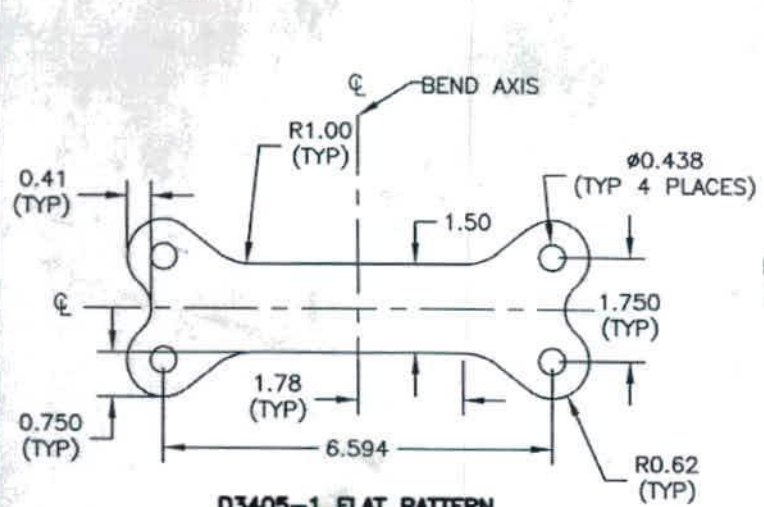
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WITHOUT NOTICE
WORK ORDER
NO. 26514

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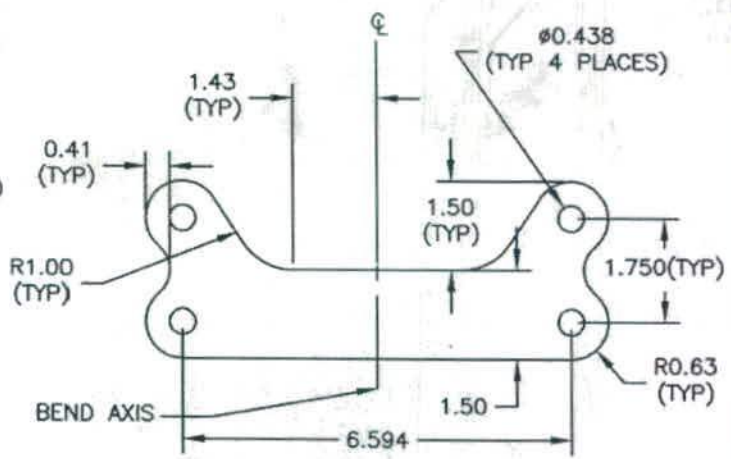
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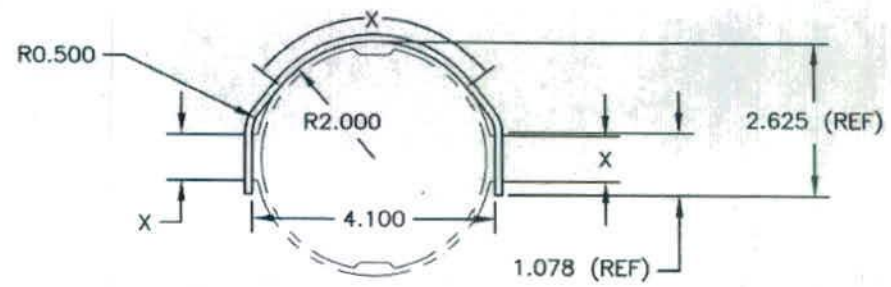
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. A
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	05.03.08	TITLE	D3405	DRAWING NO.	SHEET 2 OF 2
			GHW LUG ASSEMBLY		SCALE 1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
NO. 26514
WORK ORDER
SUBJECT TO AMENDMENT
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ENGINEERING
DEPARTMENT

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003

INDUSTRIAL LASER CUTTING + DART

04/18/2006 10:05 FAX 604 946 4153

90277641

MATERIAL TEST/INSPECTION CERTIFICATE

YIEH MAU CORP.

INVOICE NO. : P05MC11
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

工廠:高雄路竹鄉順發路845號
315, SHUN AN RD., LU CHU HSIAO
KAOHSIUNG TAIWAN R.O.C.
TEL: (07) 272685 FAX: (07) 2873005
CERTIFICATE NO. P05MC11
DATE OF ISSUE: 01/02/2006
PAGE: 4

SPECIFICATION : AISI 304
CUSTOMER : INTEGRIS METALS LTD.

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)							
			KGS	LBS			YS (kg/cm ²)	TS (kg/mm ²)	EL (%)	HRB	HV	C ≤100	Si ≤100	Mn ≤100	P ≤1000	S ≤1000	Ni ≤100	Cu ≤100	N ≤100
AISI 304, 2B FINISH, WITH PAPER INTERLEAVED, SLITTED EDGE																			
7427-4085	120A160"X 96"	1	1,444	3,183	YU140116	4B320313B-213	299	666	60	88	164	4.7	48	124	32	8	808	1650	2.8
7427-4086	120A160"X 96"	1	1,445	3,186	YU140116	4B320313D-11	299	666	60	87	164	4.7	48	124	32	8	808	1656	2.8
7427-4127	120A160"X 120"	1	1,141	2,515	YU140116	4B320313C-12	299	666	60	83	164	4.7	48	124	32	8	808	1526	2.8
7427-4127	120A160"X 120"	1	1,141	2,515	YU140116	4B320313C-13	299	666	60	83	164	4.7	48	124	32	8	808	1526	2.8
7427-4127	120A160"X 120"	1	1,141	2,516	YU140116	4B320313C-14	299	666	60	83	164	4.7	48	124	32	8	808	1526	2.8
7427-4127	120A160"X 120"	1	1,141	2,516	YU140116	4B320313C-15	299	666	60	83	164	4.7	48	124	32	8	808	1526	2.8
7427-6408	120A148"X 56"	1	1,473	3,247	YU140208	4B320313B-31	328	677	60	84	166	4.8	56	120	35	6	505	1810	3
T			8,926	19,476															
NO MERCURY CONTAMINATION																			
Dead test; good for all Heat NO.																			

Results: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE ANALYSIS DESCRIBED HEREIN WAS
RUN IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE

- PRIME MATERIAL, NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 804484 (VANCOUVER)
- SALES CONTRACT NUMBER: P05MC11
- DOCUMENTARY CREDIT NUMBER: ILCHST000293

YIEH MAU CORP.
Lin Kun Hsing
Manager of Quality Assurance Section

